

Work Order ID 71654-2

Thursday, July 07, 2011 12:06:35 PM



Page 1

Item ID: D3256-1

Revision ID:

Item Name: Panel

Start Date: 7/7/2011 Start Qty: 6.00

Required Date: 7/21/2011 Req'd Qty: 6.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: CY

QC:

Date: 11/07/07

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3256

Rev C

100



Waterjet

FLOW CNC Waterjet

304 - 032

FLOW WATER JET

Memo

1-Cut as per Dwg D3256

Dwg Rev: 6

Prog Rev: 1

2-Deburr if necessary

0.00

0.00

BS11-8-10

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

BS11-8-10

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

Sulos 111

(47)

# Work Order ID 71654

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Page 2

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Panel

Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Form using D3256-1T2

140

0.00



QC'S- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00



Identify as per dwg & Stock Location 178

Packaging

Memo

0.00

Packaging

SP 11/12/22

SS.

S 11/12/22

+6

11/12/22 SD 100

# Work Order ID 71654

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Page 3

Item ID: D3256-1

Accept



Setup Start



Revision ID:

Item Name: Panel

Stop



Start Date: 7/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/21/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/12/22  
MF 11-12-22

# Picklist Print

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Page 1

Work Order ID: 71654

Parent Item: D3256-1

Parent Item Name: Panel



Start Date: 7/7/2011

Required Date: 7/21/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-09-28 EC verified by:DD  
IPP Rev:b ECN 1052 07-10-31 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

43.3600

0.987

6.233684

7

10/11-8-10



304/316 .032 Sheet



Location

Loc Qty

Loc Code

020

5.8

109057

5.8

MAT020

37.56

117379

37.56

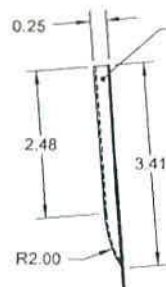
118400

118400

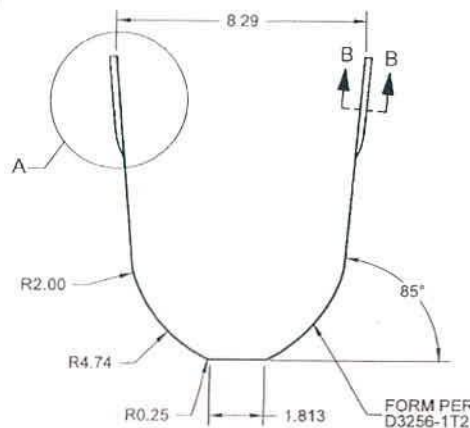
(1)



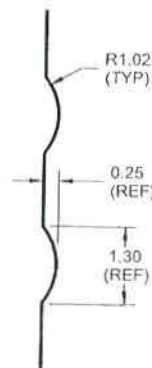
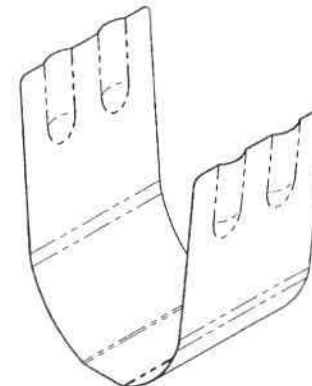
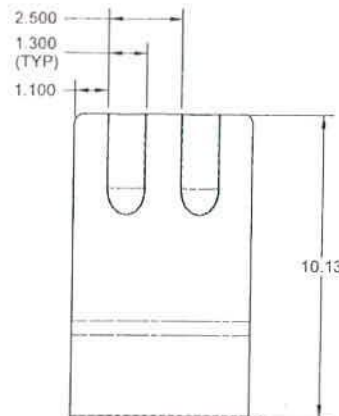




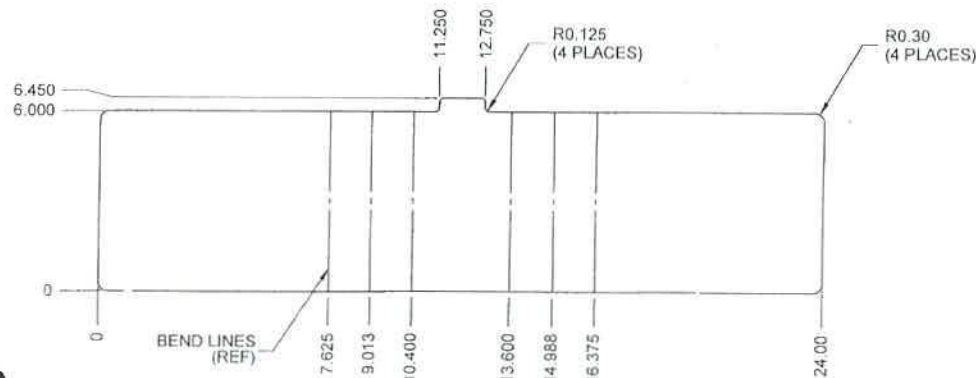
**DETAIL A**  
SCALE 1:2



**D3256-1 ACCESS PANEL**  
(MAKE FROM D3256-1F)



**SECTION B-B**  
SCALE 1:2  
(VIEW ROTATED)



**D3256-1F FLAT PATTERN**

RECEIVED  
UNCLASSIFIED  
TINYPHOTOGRAPH COPY  
SUBJECT TO APPROVAL  
WORKSHEET  
NO. 71654  
(2/11/07/10)

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET (0.032 THICK, REF) PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S22GA)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3256-1" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 1.37 lbs

C	D3256-041 ELIMINATED; REMOVED (QTY 22) 0.128 HOLES FROM D3256-1F AND D3256-3 GASKET. INSTRUCTIONS TO DRILL HOLES AND INSTALL D3256-3 GASKET ARE NOW PART OF THE INSTALLATION INSTRUCTIONS	MB	07.09.28
B	D3256-3 DIM 1.30 WAS 0.65	RF	05.06.27
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	TH		
CHECKED	TH	DRAWING NO.	REV. C
MFG. APPR.	TH	D3256	SHEET 1 OF 2
APPROVED	TH	TITLE	SCALE
DE APPR.	TH	ACCESS PANEL	1:4
DATE	07.09.28	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE TO THE PUBLIC UNLESS OTHERWISE NOTED. IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR CONVICTION TO A NEW OTHER PERSON OR FOR ANY OTHER PURPOSES TO BE USED IN THE DART AEROSPACE LTD.	

